

Work Order ID 58639

Wednesday, May 12, 2010 1:37:42 PM



Page 1

Item ID: D3684-049

Accept



Setup Start



Revision ID:

Stop



Item Name: AFT LEG ASS'Y

Start Date: 5/13/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: umfDate: 10-5-12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SP 10/06/22

(8)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

SP 10/06/22

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

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Required Date:	5/21/2010	Req'd Qty:	8.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location: <u>B9D</u>	0.00							
									
Packaging	Memo	0.00							
Packaging									

140	QC21- Final Inspection - Work Order Release	0.00							
									
QC	Memo	0.00							
Quality Control									

10.06.23

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 58639

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y

Start Date: 5/13/2010

Required Date: 5/21/2010

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Qty: 8.00

Required Qty: 8.00

AN3C12A

Purchased No 110 Each 104.0000 2



Bolts

Location Loc Qty Loc Code

ST351 104

112314 104

D3688-3

Manufactured No 110 Each 11.0000 1



STUD

Location Loc Qty Loc Code

ST080 11

51297 11

D3689-1

Manufactured No 110 Each 16.0000 1



SLEEVE

Location Loc Qty Loc Code

ST082 16

55638 11

56335 5

D3691-1

Manufactured No 110 Each 1.0000 1



STUD

Location Loc Qty Loc Code

ST082 1

54859 1

B58631

SB 10/06/22
14

SB 10/06/22
8

SB 10/06/22
4
(4)

SB 10/06/22
(8)

W/O:		WORK ORDER CHANGES					
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 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Qty: 8.00

Required Qty: 8.00

D3692-1 Manufactured No 110 Each 521.0000 4



SPACER

Location	Loc Qty	Loc Code
ST082	521	
50736	113	
51467	408	

32 SB 10/06/22

D3693-1 Manufactured No 110 Each 63.0000 1



Rod End Bearing

Location	Loc Qty	Loc Code
ST082	63	
50734	63	

8 SB 10/06/22

MS21043-3 Purchased No 110 Each 3,635.000 2



Nut

Location	Loc Qty	Loc Code
FG	80	
103691	80	
ST301	3555	
112314	3555	

16 SB 10/06/22

NAS509-12C Purchased No 110 Each 69.0000 1



Nuts

Location	Loc Qty	Loc Code
ST280	69	
112453	69	

8 SB 10/06/22

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Qty: 8.00

Required Qty: 8.00

NAS509L12C

Purchased

No

110

Each

74.0000

1



Nuts

Location

Loc Qty

Loc Code

ST280

74

112314

64

112828

10

8 SB 10/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

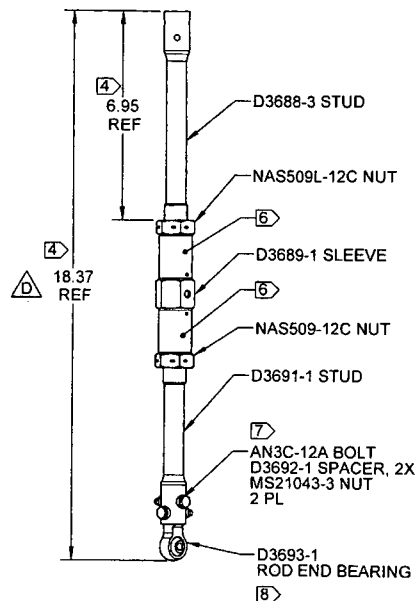
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

RELEASED
2010-03-15

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3684	REV. D
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TRIPOD MOUNT ASSY	NTS
DATE	10.03.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

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